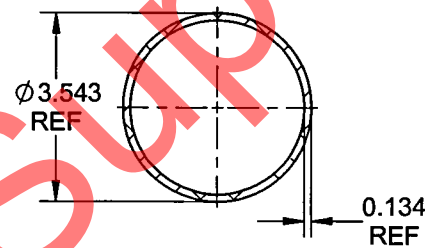


**D135-1027-153 MID HEIGHT FWD CROSSTUBE**  
BENDING AND DRILLING DETAIL



**SECTION A-A**  
SCALE 2X

**NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6025-120  
STRAIGHT LENGTH = 118.08±0.06 (BEFORE BENDING / TRIMMING)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 15.15 lbs
- 8) MAX TWIST: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE SHALL BE NO LARGER THAN 0.25.
- 9) HOLES TO BE ALIGNED WITHIN 0.005 IN RELATION TO THE HOLE ON OPPOSITE SIDE OF CROSSTUBE.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.
- 12) MAXIMUM TUBE FLATTENING DUE TO BENDING IS 2% BASED ON OD.

|            |             |  |              |
|------------|-------------|--|--------------|
| A          | NEW ISSUE   | ML   | 17.01.31     |
| REV.       | DESCRIPTION | BY   | DATE         |
| DESIGN     | ML          | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | ML          |  |              |
| CHECKED    | JMH         | DRAWING NO.  | REV. A       |
| MFG. APPR. | JLM         | D135-1027-153  | SHEET 1 OF 1 |
| APPROVED   | WM          | TITLE  | SCALE        |
| DE APPR.   | DS          | MID HEIGHT FWD XTUBE   | NTS          |
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